

Work Order ID 117163

117163

Page 1

April-24-14 10:00:09 AM

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 5/16/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/16/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1404-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00							
Packaging									

10 FF 14-08-10

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG								
	A/R PROSEAL BATCH: <u>1128703</u>								
	2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)								

10 FF 14-08-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 117163




April-24-14 10:00:09 AM

117163

Page 2

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Strut Assembly
 Start Date: 5/16/14 Start Qty: 10.00 ***10*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						16 9-89 14/08/18	DAS 38 9-89 14/08/18
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: St 366 Memo	0.00 0.00							DAS 06 9-89 AUG 18 2014
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							ML5 14-08-18  14-8-18

DQA: _____ Date: _____



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Picklist Print

April-24-14 10:00:12 AM

Page 1

Work Order ID: 117163

117163

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 5/16/14

Required Date: 5/16/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM
13.09.26 AS PER REV.B DD VERF:JLM
AS PER REV.C DD VERF:JLM
IPP
IPP REV:C
IPP REV:D 14.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	31.0000	1	10		DAS 30 9-89	
D4775-1													
Strut Tube													

Location

Loc Qty

Loc Code

GA

31

113361

10

113841

1

115177

20

D4777-1 Manufactured No

110 Each

59.0000

1

10

DAS
30
9-89

D4777-1

Rod End Bearing

Location

Loc Qty

Loc Code

ST122

48

115995

48

ST123

11

113699

11

D4776-1 Manufactured No

110 Each

22.0000

1

10

DAS
30
9-89

D4776-1

Basket Strut Clevis

Location

Loc Qty

Loc Code

ST122

21

113290

1

113660

20

ST123

1

110934

1

DQA: _____ Date: _____



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FAULT CATEGORY

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April-24-14 10:00:12 AM

Work Order ID: 117163

117163

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 5/16/14

Required Date: 5/16/14

Start Qty: 10.00

Required Qty: 10.00

D4776-5

Manufactured No

110

Each

115.0000

4

40

DAS
30
9-89

D4776-5

Spacer

14/6/18

Location

Loc Qty

Loc Code

ST122

111

B116137

40

113369

111

ST123

4

111095

3

112597

1

AN3-10A

Purchased No

110

Each

623.0000

2

20

DAS
30
9-89

AN3-10A

Bolt

14/6/18

Location

Loc Qty

Loc Code

ST351

323

m127817

43

20

m128403

280

ST511

300

m128813

150

m128936

150

MS21042L3

Purchased No

110

Each

8,088.000

2

20

DAS
30
9-89

MS21042L3

Nut

14/6/18

Location

Loc Qty

Loc Code

ST314

1133

M126333

20

M127410

92

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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Page 3

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Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 5/16/14

Required Date: 5/16/14

Start Qty: 10.00

Required Qty: 10.00

MS21209-F615

Purchased

No

110

Each

132.0000

1

10

DAS

30

9-89

14608/18

MS21209-F615

Heli-Coil

Location

Loc Qty

Loc Code

GA

132

125097

5

m128537

127

10

April-24-14 10:00:12 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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